

Date: Wednesday, 02/04/2008 11:27:06 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	6" MIRROR
Job Number :	38288		
Estimate Number :	10101		
P.O. Number :		Part Number :	D2011101
This Issue :	02/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2011 REV. F
First Issue :	1/1	Project Number :	N/A
Previous Run :	37326	Drawing Revision :	F
	Type :	Material :	
	SMALL /MED FAB	Due Date :	11/04/2008
Written By :		Qty:	50
Checked & Approved By :	JD 08.04.02	Um:	Each
Comment :	Est: J 04.09.15 Added Steps 5-7 KJ/JLM Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: 6054 Purchase Grote Mirror P/N: 28043 Possible supplier: UAP/NAPA Material release note required C 208/04/02 (50)		
2.0	28043	MIRROR 6"
Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Mirror 6"		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached 4/4/03 (50)		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK 808/04/05 (50)		
5.0	D30141	Locknut
Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Locknut Pick: Qty Part Number Description Batch 1 D3014-1 Lock nut 618605 ✓ ml 08/04/07		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:06 AM
User: Julie Lécocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 38288

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer M107008

✓

ml 08/04/07

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number Description Batch

9ml N/A Sikaflex-291/-241 M105585

Expiry date 10/2008

Start: 08/04/07 Time: 10:30 AM

Finish: 10:30 AM

ml 08/04/07

8.0

QC5

8/4/07

8:00 AM

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4- Test assembly to 50lbs pull test after 24 hours

8 08/04/07 (XSD)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 027

8/4/07

SP

(50X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/07

Job Completion



mf

08-04-09

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

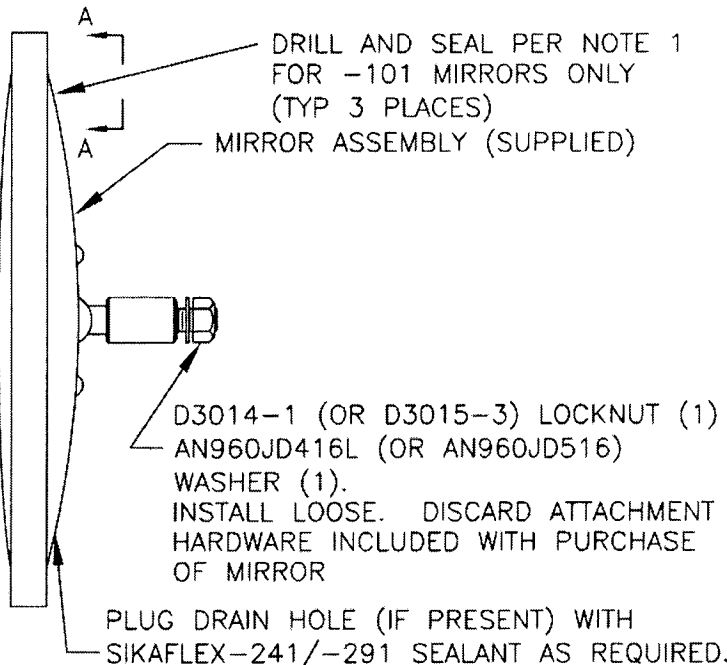
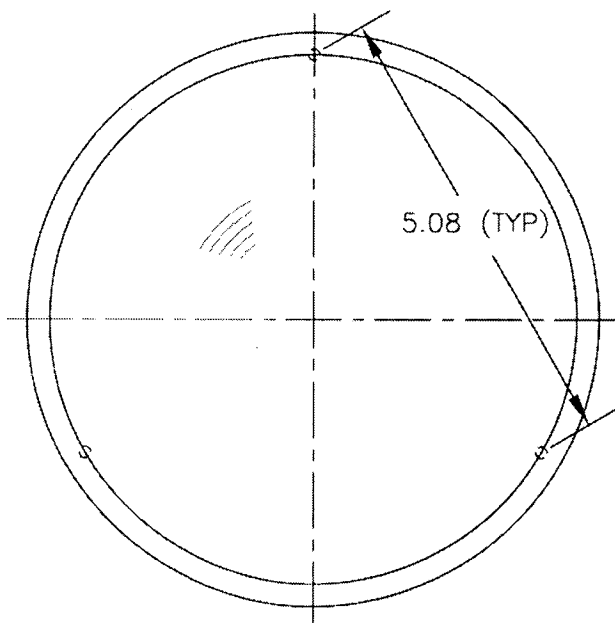
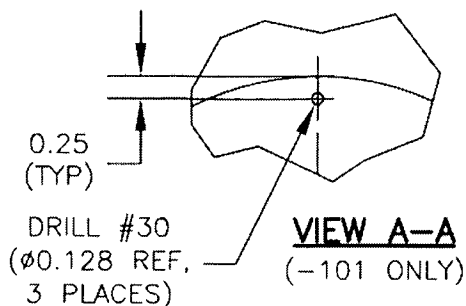
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE 04.09.10	TITLE MIRROR ASSEMBLY		SCALE 1:2
-	90.03.31	NEW ISSUE	
A	90.06.15	DWG No. WAS DSP1011, ADDED -103	
B	98.04.09	SIKAFLEX 241 ADDED	
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN	
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD	
E	01.05.08	NEW 8" MIRROR	
F	04.09.10	ADD HOLES FOR SEALANT ON -101	



QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38288

Copyright © 1990 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



**AUTO PARTS • PIÈCES D'AUTO
TRUCK PARTS • PIÈCES DE CAMION
ENGINE-MARINE • MOTEUR-MARINE
PERFORMANCE PARTS • PIÈCES DE PERFORMANCE
TIRES • PNEUS**



Past due accounts bear 2% interest per month (24% per annum). If this account is placed with a 3rd party collection, an administrative cost of 25% will be added. All exchanges and refund claims must be accompanied by this invoice. Electrical parts not returnable. All parts returned are subject to 20% handling charge. All merchandise sold on this invoice remains the vendor's property until this invoice is paid in full.
TERMS: Payment due on 10th day of the following month.

Aucun remboursement sans cette facture. Net 30 jours, 2% de frais d'intérêt par mois (24% par année) sur compte en souffrance. 20% de frais de manutention sur toute marchandise retournée. Clause pénale une indemnité de 25% sera chargée sur compte sujet à des procédures légales. Les marchandises mentionnées sur cette facture demeurent la propriété du vendeur tant qu'elles ne seront pas entièrement payées. Pièces électriques non-retournables.
TERMS: Compte payable le 10 du mois suivant.

SIGNATURE _____

GST / TPS
10035 3366 RT0001

1000 RUE LANDSDOWNE
TEL: (613)632-1191

HAWKESBURY, ON K6A 1H7
FAX: (613)632-2350

TVQ
1016330716 TQ0001

Pour chaque tranche d'achat de \$200 de produits Walter entre le 15 mars et le 15 avril>>> une chance de gagner une TV a ecran plat 32". Contactez votre Rep.

113336 (613)632-5200
DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

EXP
SHIP
TO
A

113336

*** SAME ***

DATE: 4/03/08
08:56
111 M/LP

PO: 0000-6354

ORD / COM	SHIP / EXP	CODE	PART No / PIÈCES	DESCRIPTION	LIST EACH / CHACUN	COST / COÛTANT	EXTENSION
10	50	038	28043	6" CONVEX ASSEMBLY	43.09	15.60	730.00
	50	***	direct grote	PIECES/CORE TOT	0.00		0.00
			SHIP VIA	REGULAR			
INVOICE No / FACTURE	TYPE / SORTE	TOTAL	DISC / ESC	FRT / TRANS	GST / TPS	PST / TVQ	AMT to PAY / À PAYER
10366134	INVOICE	730.00	0.00	0.00	39.00	0.00	819.00